

12

Date: Monday, 2/25/2008 11:14:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASS'Y (A119) PRELIMINARY
 Job Number : 37590B
 Estimate Number : 12431
 P.O. Number :
 This Issue : 2/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3516041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3516 REV C PREMIL
 Previous Run : 31751B Drawing Revision : C
 Material :
 Due Date : 3/17/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : EST rev. A 06.05.31 Preliminary EC
 EST rev. b 06.07.27 updated EC
 Est Rev:C 08-02-25 ECN 1138P DD verified by:



PRELIMINARY ISSUE

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

Batch: B34610

PD 08-03-06

2.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B36481

PD 08-03-06

3.0 D351611 CLEVIS



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLEVIS

batch: B31626

PD 08-03-06

4.0 D351613 CLEVIS



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

CLEVIS

batch: B31801

PD 08-03-06

5.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B36697

PD 08-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge B36846

Batch: ~~B36846~~

PD 08-03-06

7.0

D31661

Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIB

Batch: B37156

PD 08-03-06

8.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch B37626-1

PD 08-03-06

9.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: B106199

PD 08-03-06

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

5- Cut rib D3516-15 as per dwg D3516




6-Cut rib D3516-9 from D3166-1 (4)

PD 08-03-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/05	# 11.0	During welding it was found that the Basket RBS (D3516-9) were cut 3" too long. R.C DT wasn't indicated on the w/o. and the wrong sequence of bolts were used	 08/03/05	Remove/cut top beam off nonconforming Basket RBS. Scrap the entire Base Replace all D3516-9 B36859 1x B# B37324 3x and re weld as per Dwg D3516 As per 087004 Replace all D3516-7 B# B106199 Replace all D3516-5 B# B106199 ADD DT B365 to I.P.P.	08-03-05 PD 08-03-05 PD 08-03-05 PD 08-03-05 PD 08-03-05 PD 08/03/07	08/03/07 08/03/07 08/03/07 08/03/07 08/03/07 08/03/07 08/03/07 08/03/07 08/03/07 08/03/07	 08/03/05	 08/03/05

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



PD
Previous Page

Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

PD 08-03-07

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/10

13.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 60.0000 sf(s)/Unit Total: 60.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: m 10-1218

FC 08 03 12

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

FC

2-Cut expanded metal for base ends as per dwg D3516

FC

3-Weld expanded metal to base as per dwg D3516

FC

08 03 12

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-13

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-13

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m 107005

FL/M 08/03/14

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 08-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G14.

mf 08-03-14

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-03-17

POSITIVE RECALL

EFFECTIVE 08-02-16 AUTH U

RELEASED 08-03-17 DATE U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

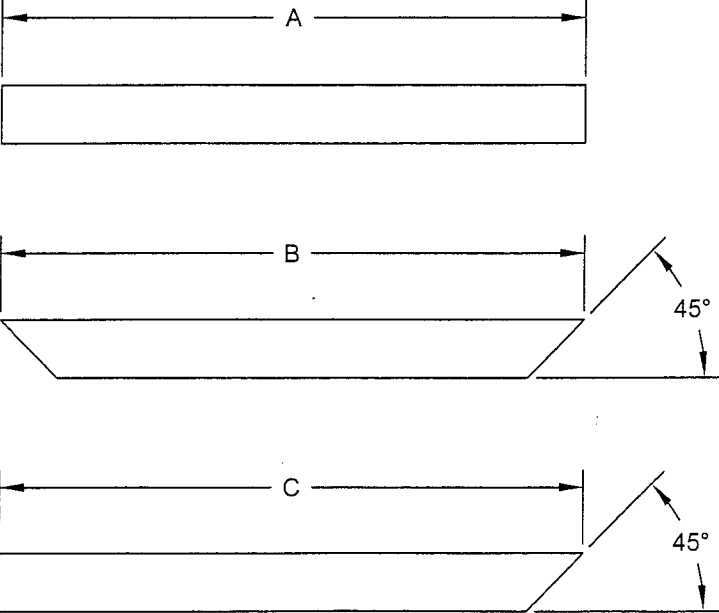
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3 ✓	2	N/A	N/A	N/A	HINGE PLATE
D2327-3 ✓	2	N/A	N/A	N/A	BUSHING
D2581 ✓	2	N/A	N/A	N/A	MOUNTING BRAKET
D3442-1 ✓	2	N/A	N/A	N/A	SHIM
D3516-1 ✓	2	—	102.00	—	RIB
D3516-3 ✓	2	—	—	2.70	RIB
D3516-5 ✓	8	26.75	—	—	RIB
D3516-7 ✓	3	45.50	—	—	RIB
D3516-9 ✓	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11 ✓	6	N/A	N/A	N/A	CLEVIS
D3516-13 ✓	4	N/A	N/A	N/A	CLEVIS
D3516-15 ✓	2	—	—	19.32	RIB
D3725-1 ✓	2	N/A	N/A	N/A	HOOP



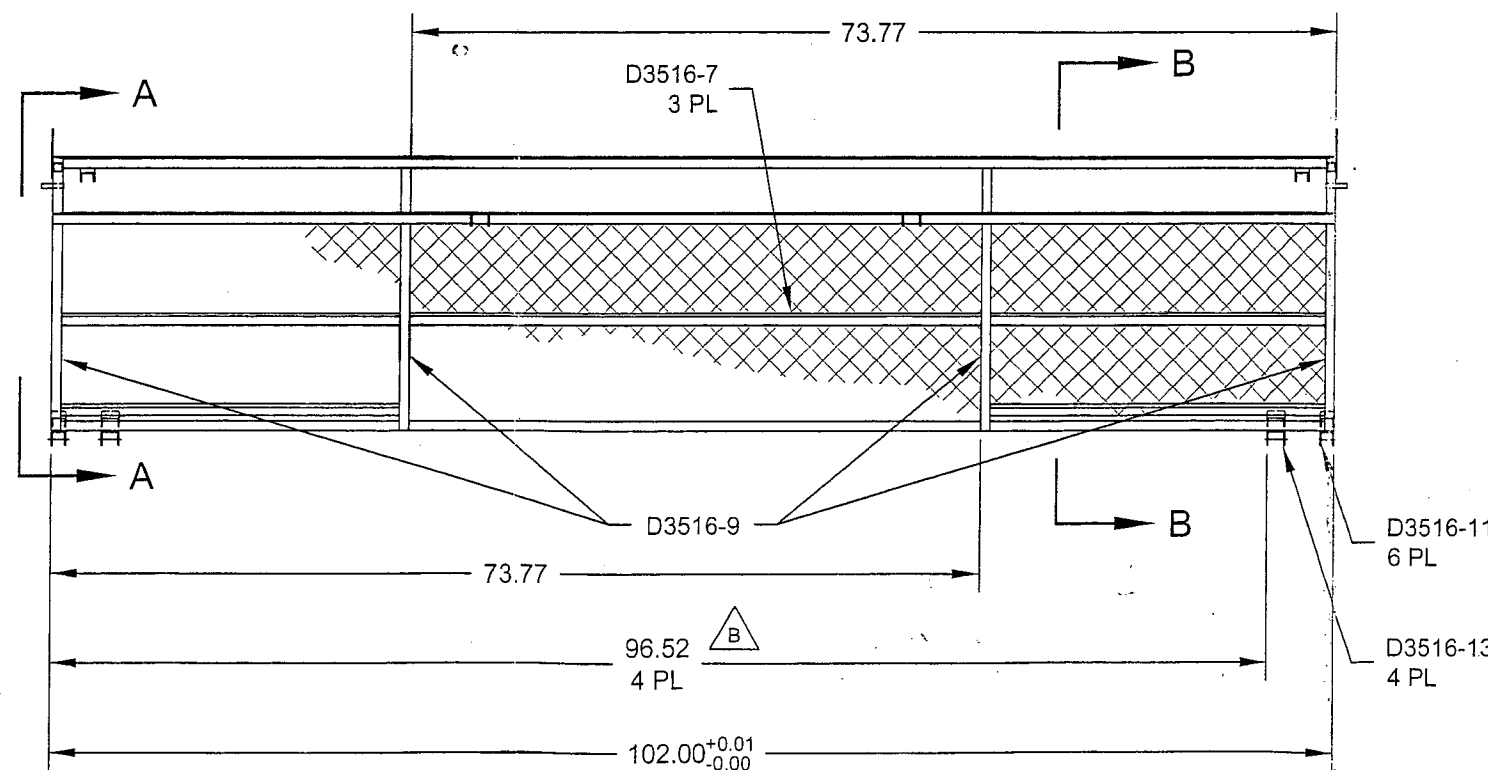
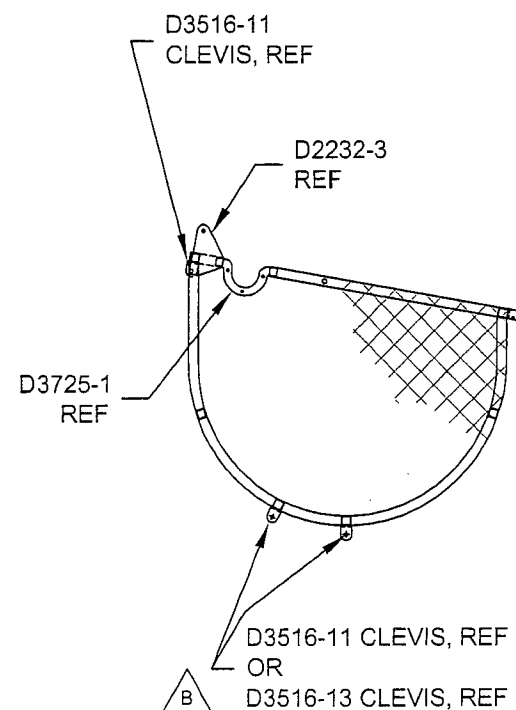
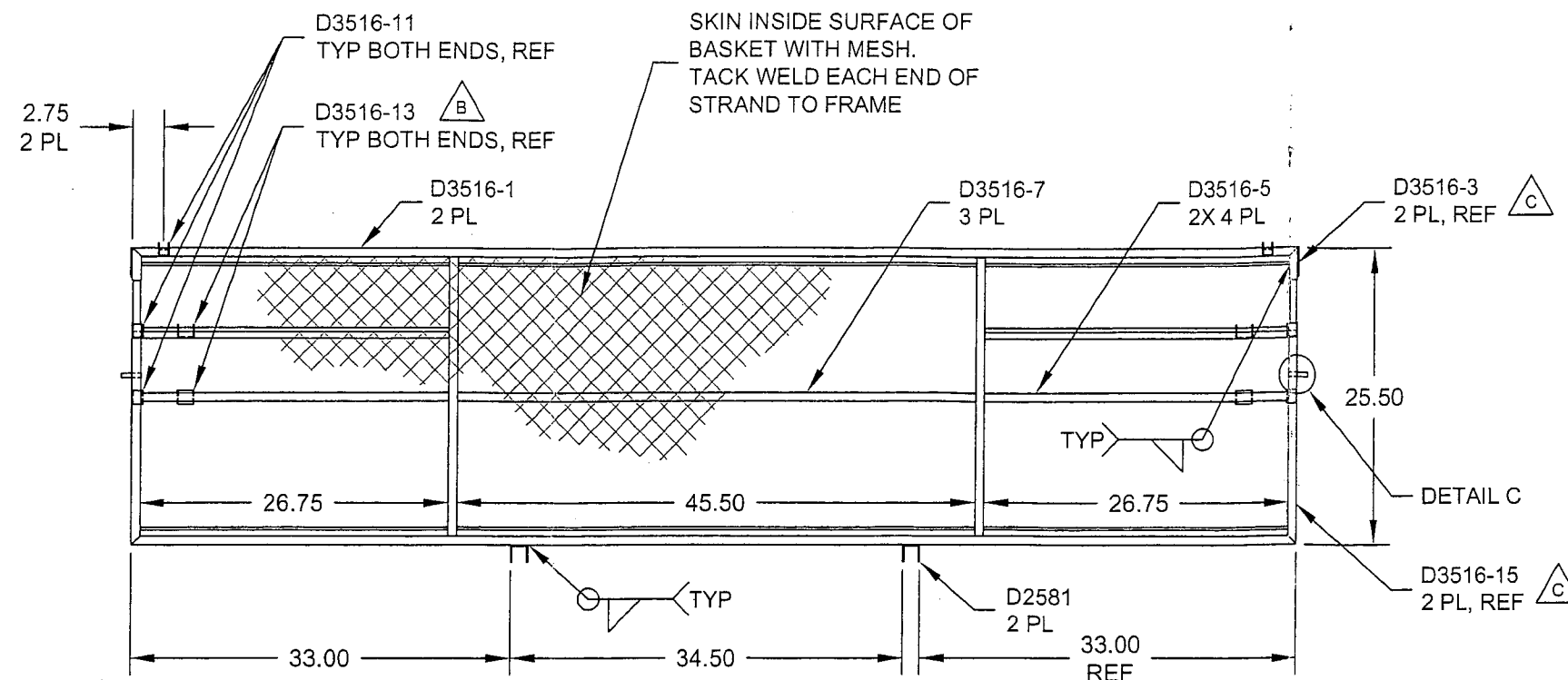
D3615-041 BASKET BASE ASSEMBLY NOTES:

- 1) MATERIAL:
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL
(REF. DART SPEC. M304TS0.750W.065)
MESH - 3/4-16F EXPANDED STAINLESS STEEL
(REF. DART SPEC. M304EX0.75-16F)
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 75 lbs
- 8) WELDING: PER DART QSI 004

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PRELIMINARY ISSUE

C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(8) D3516-11 WAS QTY.91) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
DATE	08.02.20	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

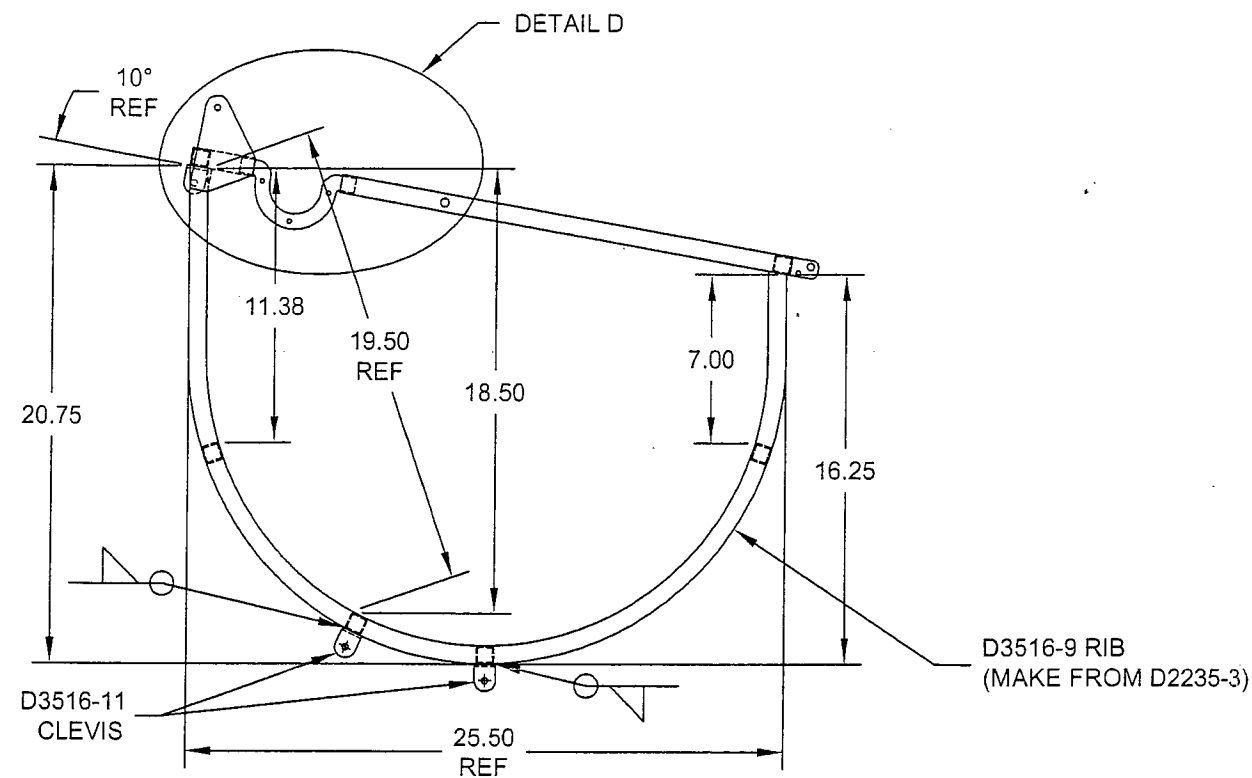


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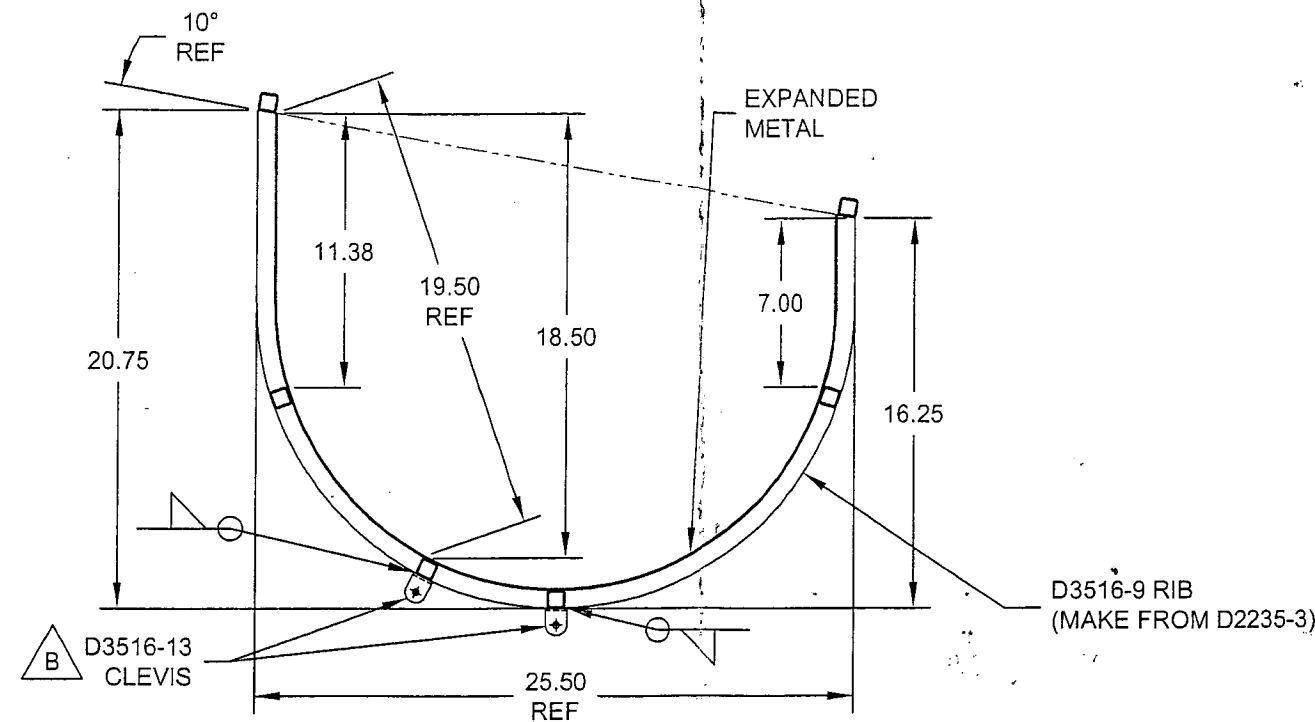
PRELIMINARY ISSUE
08-02-22

D3516-041 BASKET BASE ASSEMBLY

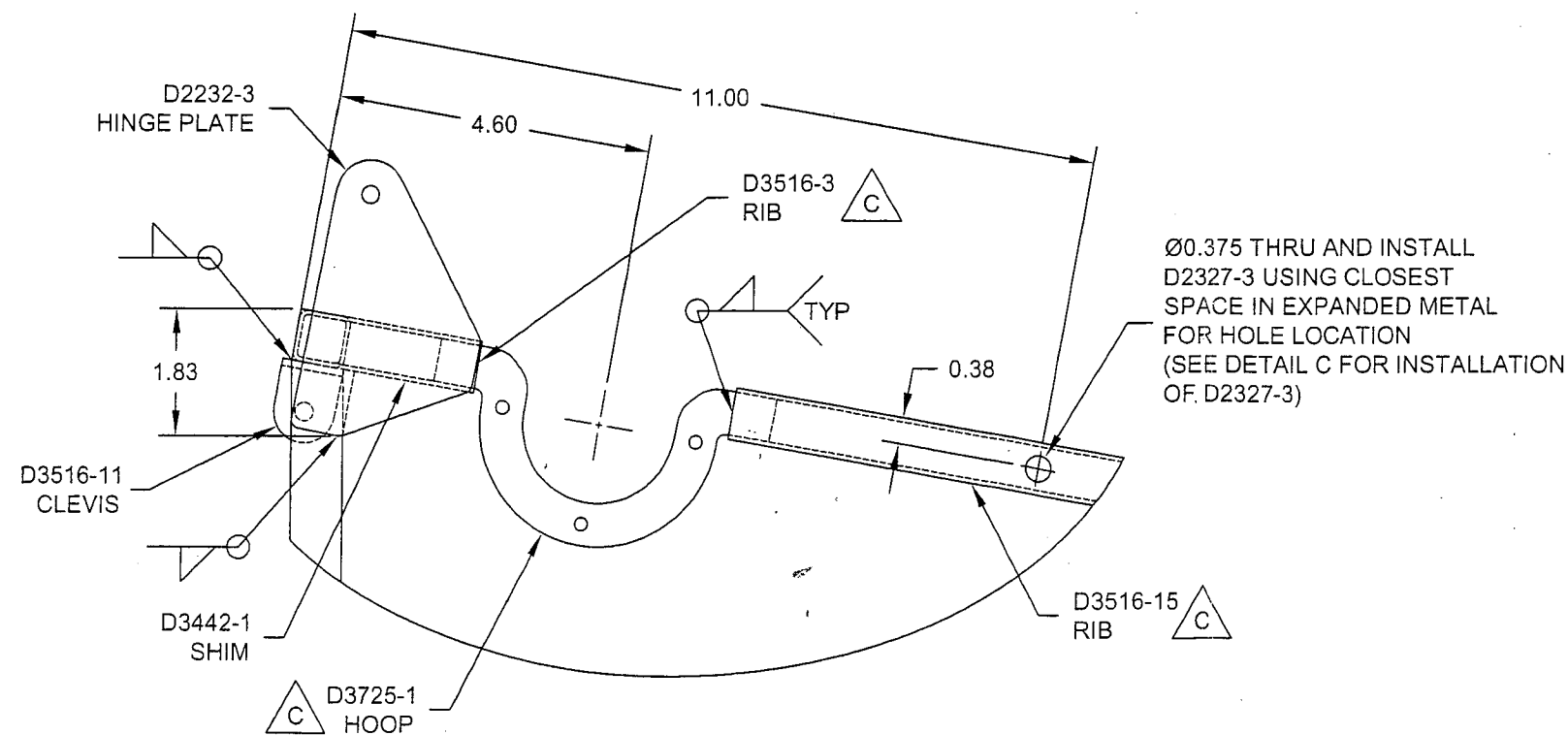
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (A119)	NTS
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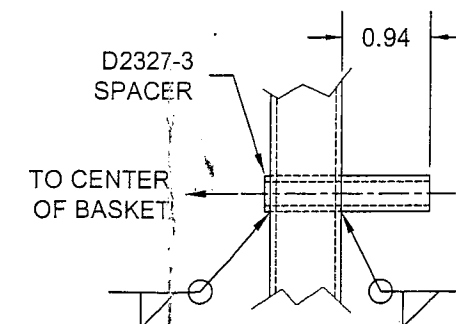
SECTION A-A: END RIB DETAIL
TYP BOTH ENDS



SECTION B-B: CENTER RIB DETAIL
2 PL



DETAIL D: HOOP & HINGE PLATE DETAIL
FRONT SHOWN, BACK SIMILAR
SCALE 3X

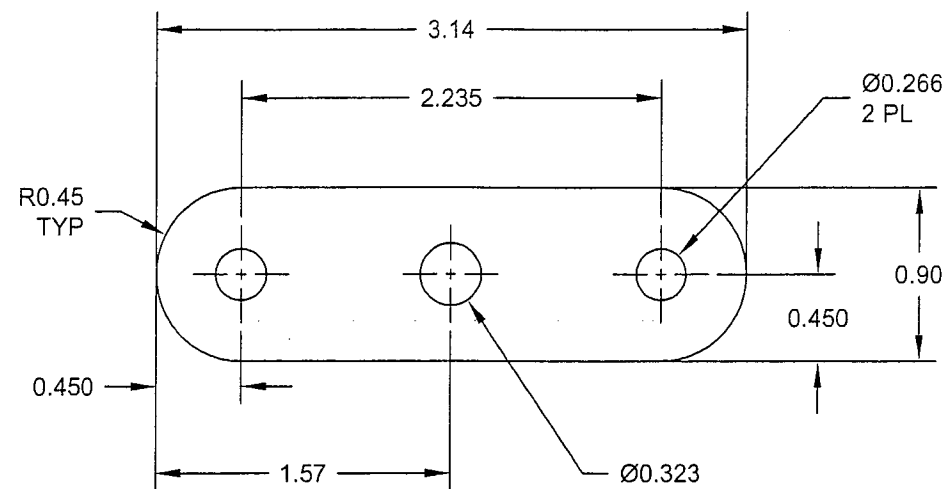


DETAIL C: SPACER INSTALLATION
SCALE 4X

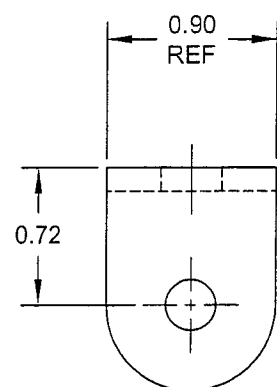
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PRELIMINARY ISSUE 08.02.20

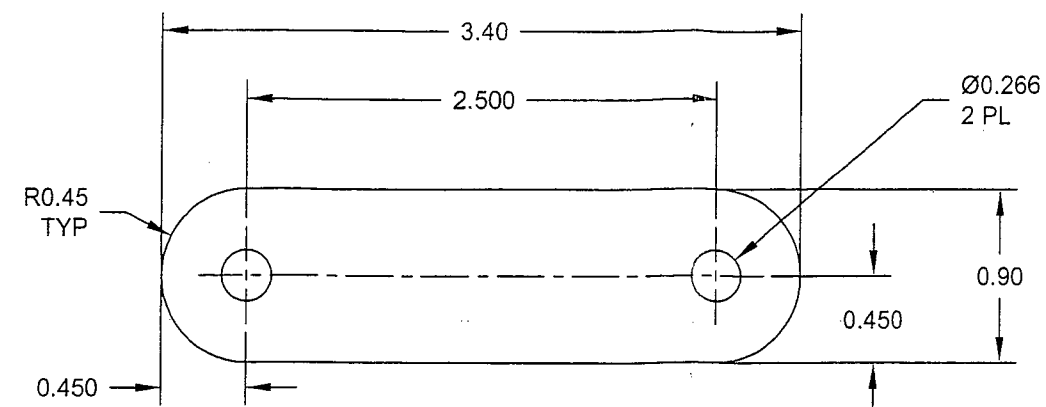
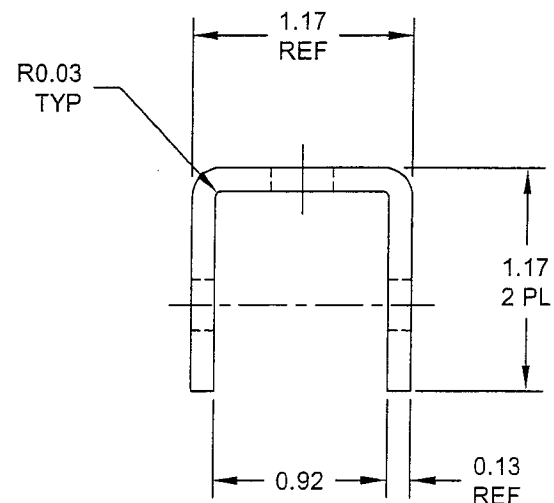
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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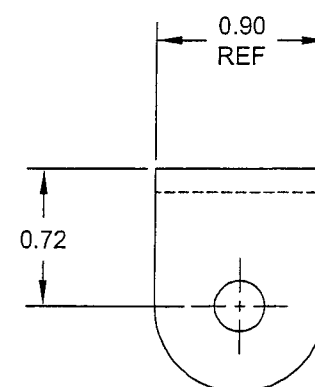
1 D3516-11F CLEVIS FLAT PATTERN



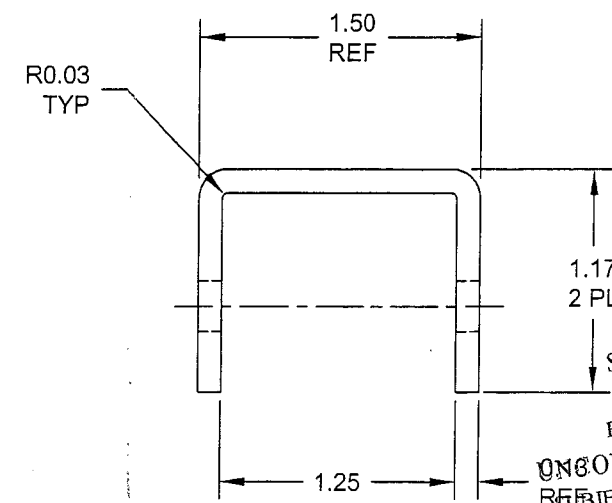
D3516-11 CLEVIS BENDING DETAIL
(MAKE FROM D3516-11F)



1 D3516-13F CLEVIS FLAT PATTERN



D3516-13 CLEVIS BENDING DETAIL
(MAKE FROM D3516-13F)






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PRELIMINARY ISSUE

D3516-11/-13 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs
D3516-13 = 0.10 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3516 SHEET 4 OF 4
APPROVED		TITLE SCALE
DE APPR.		BASKET BASE ASSEMBLY (A119) NT
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